

Work Order ID 116989-1

116989

Page 1

June-09-14 2:31:32 PM

Item ID: D4095-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 4/23/14 Start Qty: 12.00

10

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 12.00

10

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

B

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24577
CUT PER DRWG D4095 REV.B

C214106/12 12

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

4/4/14 (12)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

DAS

37
989

10

Work Order ID 116989

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116989

Page 2

Item ID: D4095-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 4/23/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				12			14/07/15
Brake NC	Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00		DAS 30 9-89					
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				10			
Quality Control	Memo Ensure joggle as per dwg D4095	0.00							
150 *150* Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M130145</u>	0.00				6			EA/MAL 14-10-29
Large Fab	Memo	0.00							

Work Order ID 116989

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Page 3

June-09-14 2:31:32 PM

Item ID: D4095-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 4/23/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 38 9-89
160						(6)	14-10-30		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
170						(6)	14-10-30		
QC	Memo	0.00							
Quality Control									
180		0.00							
180						(6)		CA 14-10-30	
HandFinish	Memo	0.00							
Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 130617								

1 16989

June-09-14 2:31:32 PM

N900040100

Setup Start *NS1*

Stop *NS2*

12

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

190

0.00

OCT 31 2014

0.00

200

0.00

DAS
46
9-89
NOV 03 2014

0.00

210

0.00

Quality Control

NOV 10 1967

Picklist Print

June-09-14 2:31:32 PM

Page 1

Work Order ID: 116989

116989

Parent Item: D4095-041

D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

144.8670

2.275

29

M304S16GA

**

CH 18/06/19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

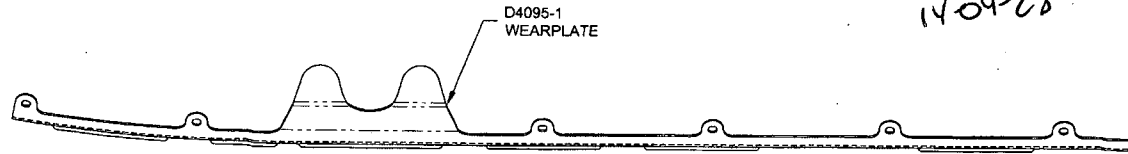
M129192

68.1

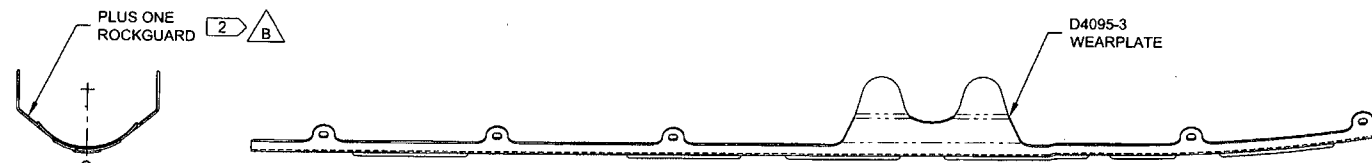
m129545

ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

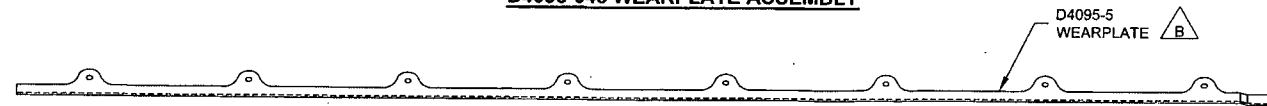
116989 MJS
1404-28



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY

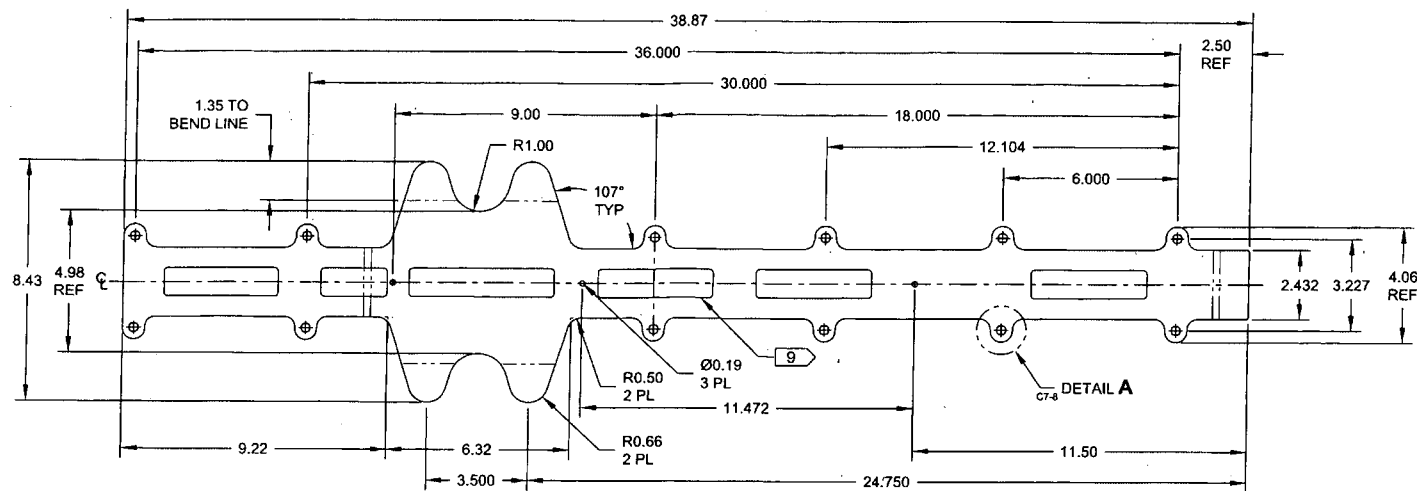


D4095-045 WEARPLATE ASSEMBLY

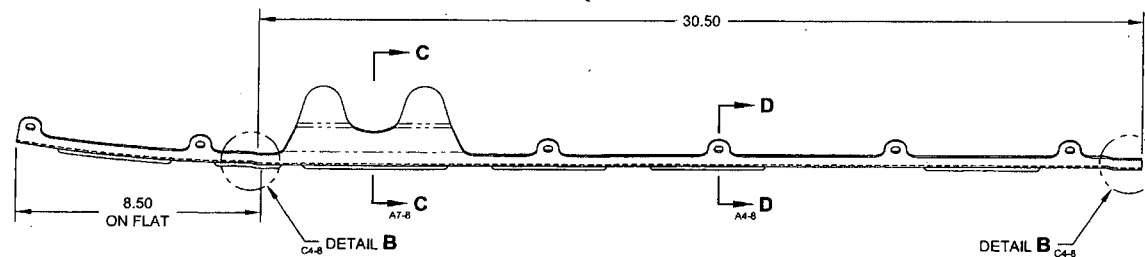
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
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D4095-1F FLAT PATTERN 1



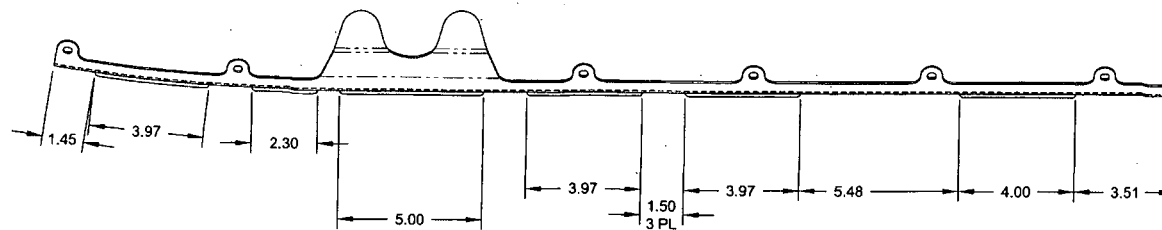
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-11-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

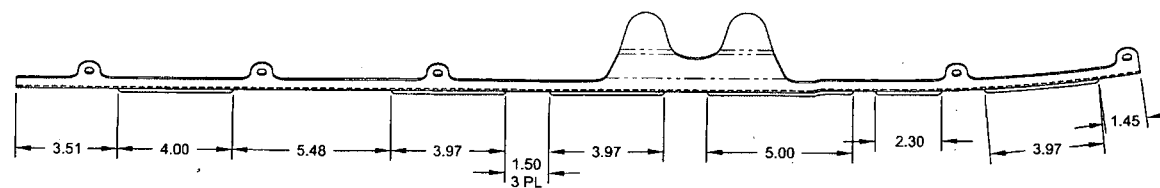
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT \bar{C}

DESIGN		DART AEROSPACE USA, INC	
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CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 3 OF 8
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DE APPR.	10	WEARPLATE	NTS
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RELEASED
2011-10-31
MPC



D4095-1 WELDING DETAIL

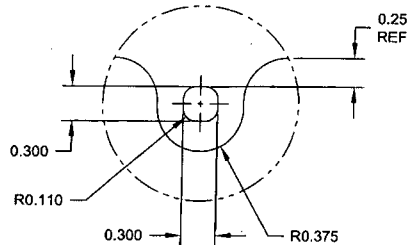


D4095-3 WELDING DETAIL



RELEASED
2011-10-31
M

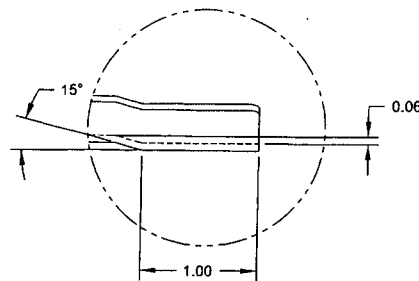
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 5 OF 8
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DETAIL A: TAB DETAIL

SCALE 4X

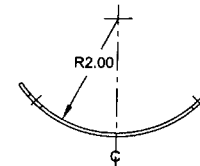
C3-3
C2-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

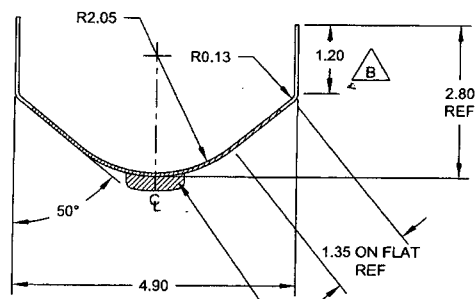
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

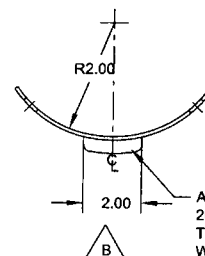


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

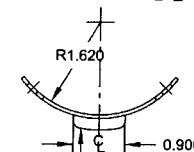


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
JMD

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AD	DRAWING NO.	REV. B
MFG. APPR.	AD	D4095	SHEET 8 OF 8
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	WEARPLATE	NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
 DELSON, QUÉBEC J5B 1V4
 CANADA
 Tel: (450) 633-0484
 Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
 Date: 2014-07-02
 Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	24
d3537-1	Chaque	d3537-1 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	60
d2154	Chaque	d2154 bracket stud	20
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	40
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	12
d4952-1	Chaque	d4952-1 wearplate	16
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	20
d4095-047	Chaque	d4095-047 wearplate assy	16
d4798-041	Chaque	d4798-041 wearplate assy	20
d4135-1	Chaque	d4135-1 wearpad	16
d4360-041	Chaque	d4360-041 wearplate assy	10
d2012-111	Chaque	d2012-111 bracket	8
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	40
d3171-1	Chaque	d3171-1 angle bracket	60
d3463-3	Chaque	d3463-3 step	20
d3512-1	Chaque	d3512-1 wearplate	12
d3629-1	Chaque	d3629-1 bracket	16
d3955-5	Chaque	d3955-5 plate	20
d4021-5	Chaque	d4021-5 blanking plate	12
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days